

Date: Wednesday, 8/8/2007 4:16:04 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL ROTOR PEDAL DISABLING KIT
Job Number	: 33814		
Estimate Number	: 12334		
P.O. Number	: N/A	Part Number	: D3371041
This Issue	: 8/1/2007 S.O. No. : N/A	Drawing Number	: D3371 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 32242	Material	: N/A
Written By	: <u>JP/07-08-01</u>	Due Date	: 8/8/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev: A Removed from 9 Digit 06-03-10 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33711	Pedal Lock Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3371-1	Pedal Lock Base	B22287 -

2.0	D33713	Pedal Lock Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3371-3	Pedal Lock Cover	B22288 -

3.0	D33853	Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3385-3	Hinge	B22387 -

4.0	D27287	Decal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Decal	B22554 -

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 33814

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33737

Cam Lock



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3373-7

Cam Lock

B22610, B22944, B26212

6.0

AN526C832R6

Screw



EP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN526C832R6

Screw

M2039(2x)

M16612(2x) -

7.0

238028

3/16" Dowel Pin .5" long



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 238-028

3/16" dia. Dowel Pin 1/2" long

M16988 -

A/R N/A

Locktite 262

M102855

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty Part Number

Description

Batch

A/R

262 Locktite

M102855

9.0

D33841

Cyclic Sock



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3384-1

Cyclic Sock

B26372 -

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 33814

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

CBL460

Loop Sleeve

*EP*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve *B M103927*

11.0

CBL1240

Cable

*EP*

Comment: Qty.: 1.7499 f(s)/Unit Total : 1.7499 f(s)

Pick:

Qty Part Number Description Batch

20" CBL-1240 Cable *M102439*

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard to cyclic sock as per Dwg D3384

Identify as D3384-045

m107/08/02 XI

13.0

AN960416

Washer

*EP*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer *M5519*

14.0

HX81

1/4"-20 SHCS 3/8" long

*EP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long *b16971**EP 07/08/02*

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.

Identify as D3371-041 & attach keys

Record the Key Number on page 4

EP 07-08-02

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 33814

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



JLM/07-08-02

Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

Record Key #

C108A

JLM

18.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

JLM/07-08-02

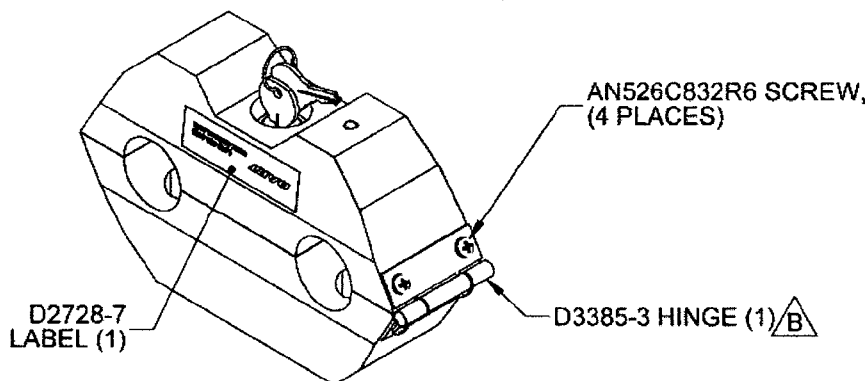
Job Completion



JLM/07-08-02

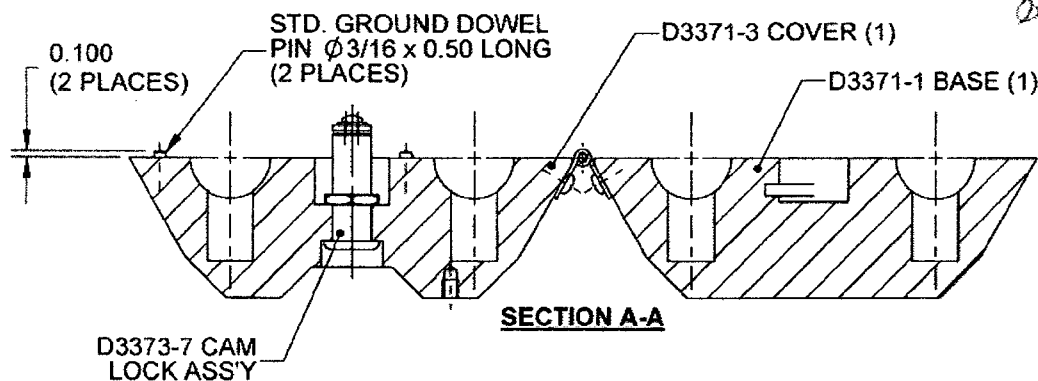


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

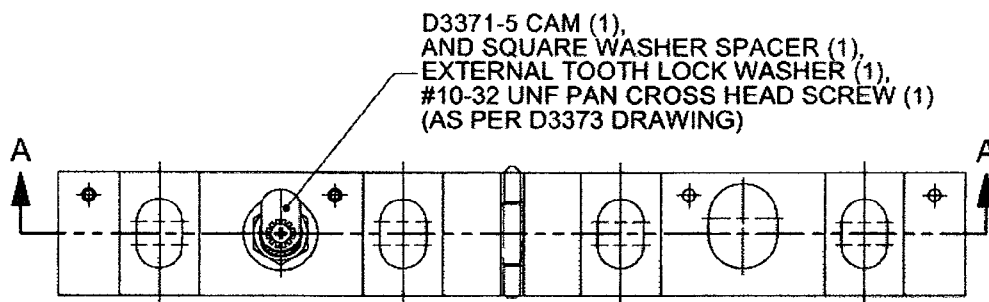


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

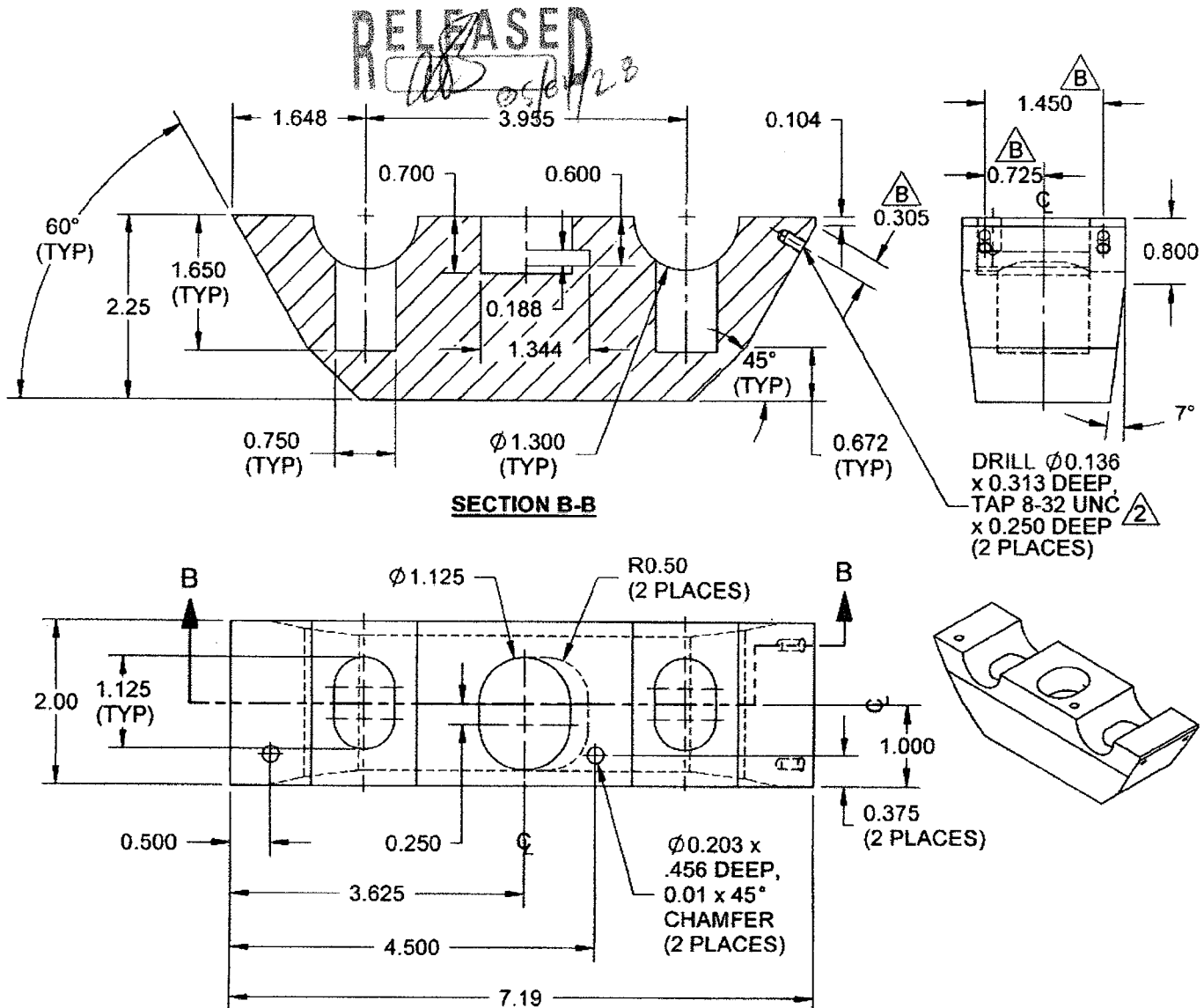
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DESIGN 45	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

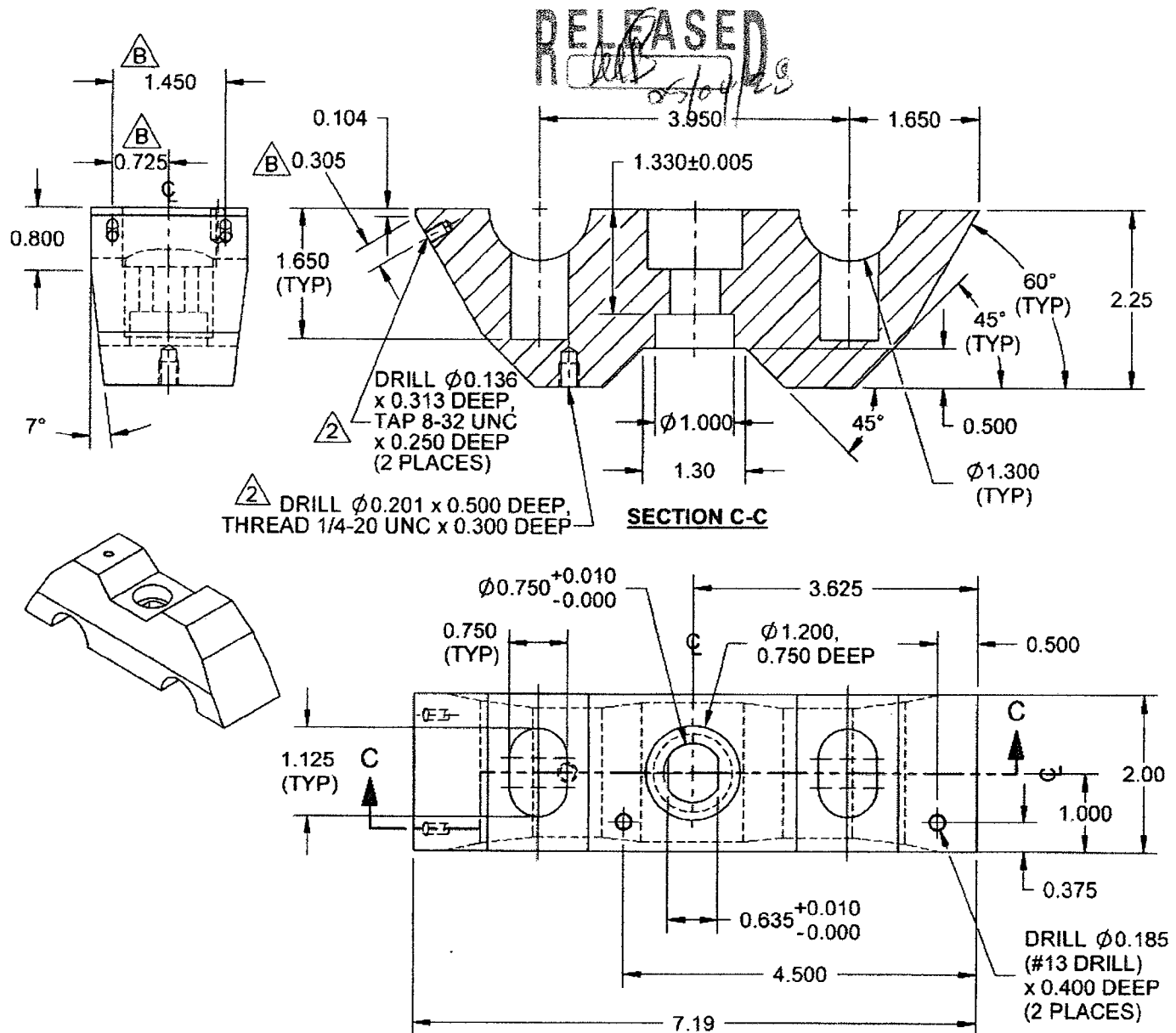
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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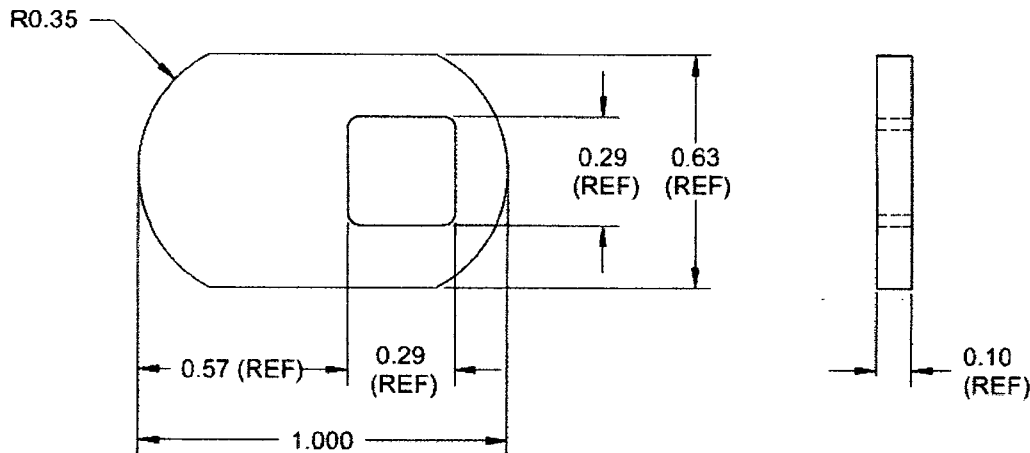
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B
DATE 05.03.22		TITLE PEDAL LOCK	SHEET 4 OF 4 SCALE 2:1

RELEASED
[Signature]
05/04/23

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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